

Work Order ID 75911

November-02-11 10:11:29 AM

75911

U/R

Page 1

Item ID: D412-742-043

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Replacement Float Skidtube

Stop

NS2

Start Date: 01/11/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 15/11/2011 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/03 Tooling: _____ Date: _____

Run

Start

NR1

QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--	----------------------------------	------------------------------	----------------	---------------	----------------------	-----------------------	-----------------------	--------------------------	------------------------

Draw Nbr	Revision Nbr								
D3391	H U/R	<i>Q11.11.07</i>							
100			0.00						
100	DOCUMENT CONTROL								
DC	Memo		0.00						
Document Control	If D412-742-043 is a W/O on its own, Photocopy bluefile and create labels per PPP D412-742-043		CHG004						

CHG005
Q11.11.08

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

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Revision ID:

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Start Date: 01/11/2011 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

110

HandFinishing

0.00

1

6

11/11/23

HandFinish

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex
241/291. Ensure tube ends line-up with saddle holes for proper alignment. using
7/16" "T" Pins.

A/RSikaflex-241/-291 11/11/443

Expiry date: 12/10/11

✓ 2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against
wearplate, then topped with the SS washer. Seal all bolts with sikaflex except
ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/RSikaflex-241/-291 11/11/443

Expiry date: 12/10/11

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with
MEK degreaser.

A/RLPS Procyon 11/11/444

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NS1

Revision ID:

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Stop

NS2

Start Date: 01/11/2011 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 15/11/2011 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

0.00 5/11/2013

(Y)

130

130

Packaging

Packaging

0.00

0.00

PP75900

(Y)

Packaging

Memo

Identify and pack for shipping as per PPP D412-742-043
Location: _____
PPP Rev: _____

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

12/1/13

MF
12-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 75911

75911
D412-742-043

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM

IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC

IPP Rev:C 07-05-28 As per Rev F JLM

IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM

IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F

11.11.01 as per DSI9517 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A		Purchased		No		110	Each	2,389.000	24	24	**	11/12/20	

AN3C4A

BOLT

Location	Loc Qty	Loc Code
ST350	2389	
117313	2	
117688	5	
117872	22	
118112	16	
118451	2	
118706	364	
118838	978	X24
119328	1000	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 75911

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Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

110

Each

276.0000

10

/6 8

**

M119749 (x8) M1112120

AN3C6A

BOLT

Location	Loc Qty	Loc Code
FP-A	1	
111982	1	
ST350	100	
119449	100	
ST351	175	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	120	

AN3C7A

Purchased

No

110

Each

131.0000

4

4

**

M1112120

AN3C7A

BOLT

Location	Loc Qty	Loc Code
ST351	131	
113149	14	
116169	1	
117313	10	
117619	12	
117688	18	
118422	76	X4

AN960C10L

NAS1149C0332

R

Purchased

No

110

Each

0.0000

38

38

**

M119736 (v38) M1112120

*AN960C10L *

washer

W/O: 75911		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/12/20	110	Replace (2x) AN3C-6A bolts with AN3C-5A / M119749 bolts For proper fit	jl	11/12/20	x2	W	C Dale

Part No: D412-742-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D412-742-043

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Parent Item Name: Replacement Float Skidtube

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3391-021

Manufactured No

110

Each

0.0000

1

1

**

B76388 (x1) M u(12|20)

D3391-021

Fwd Tube Assembly

D3391-023

Manufactured No

110

Each

0.0000

1

1

**

B75958 (x1) M u(12|20)

D3391-023

Mid Tube Assembly

D3391-025

Manufactured No

110

Each

0.0000

1

1

**

B76397 (x1) M u(12|20)

D3391-025

Aft Tube Assembly

D3564-5

Manufactured No

110

Each

14.0000

1

1

**

B77737 (x1) M u(12|20)

D3564-5

Wearshoe

1.12.23

Location	Loc Qty	Loc Code
----------	---------	----------

FG	2	
----	---	--

34806	2	
-------	---	--

FP19	12	
------	----	--

73330	12	
-------	----	--

D3566-5

Manufactured No

110

Each

34.0000

1

1

**

N/A

D3566-5

Gasket

1.12.23

Location	Loc Qty	Loc Code
----------	---------	----------

FP002	34	
-------	----	--

74387	12	
-------	----	--

75069	22	
-------	----	--

D4095-041

Manufactured No

110

Each

10.0000

1

1

**

B76534 (x1) M u(12|20)

D4095-041

Wearplate Assembly

Location	Loc Qty	Loc Code
----------	---------	----------

ST	10	
----	----	--

74852	10	
-------	----	--

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4095-043

Manufactured No

110

Each

10.0000

1

1

**

B76535 (x1) Del 11/12/20

D4095-043

Wearplate Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST	10	
74853	10	

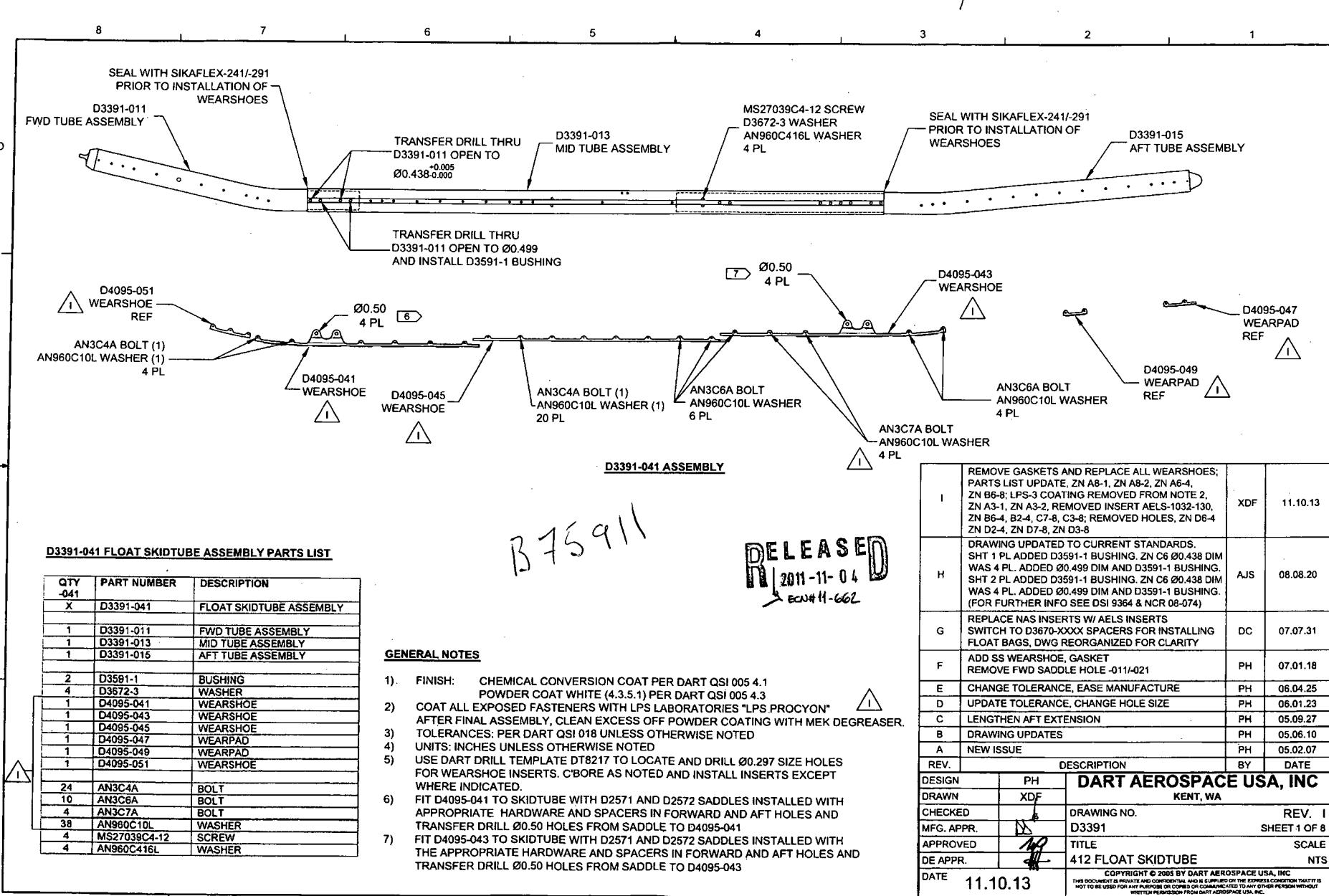
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

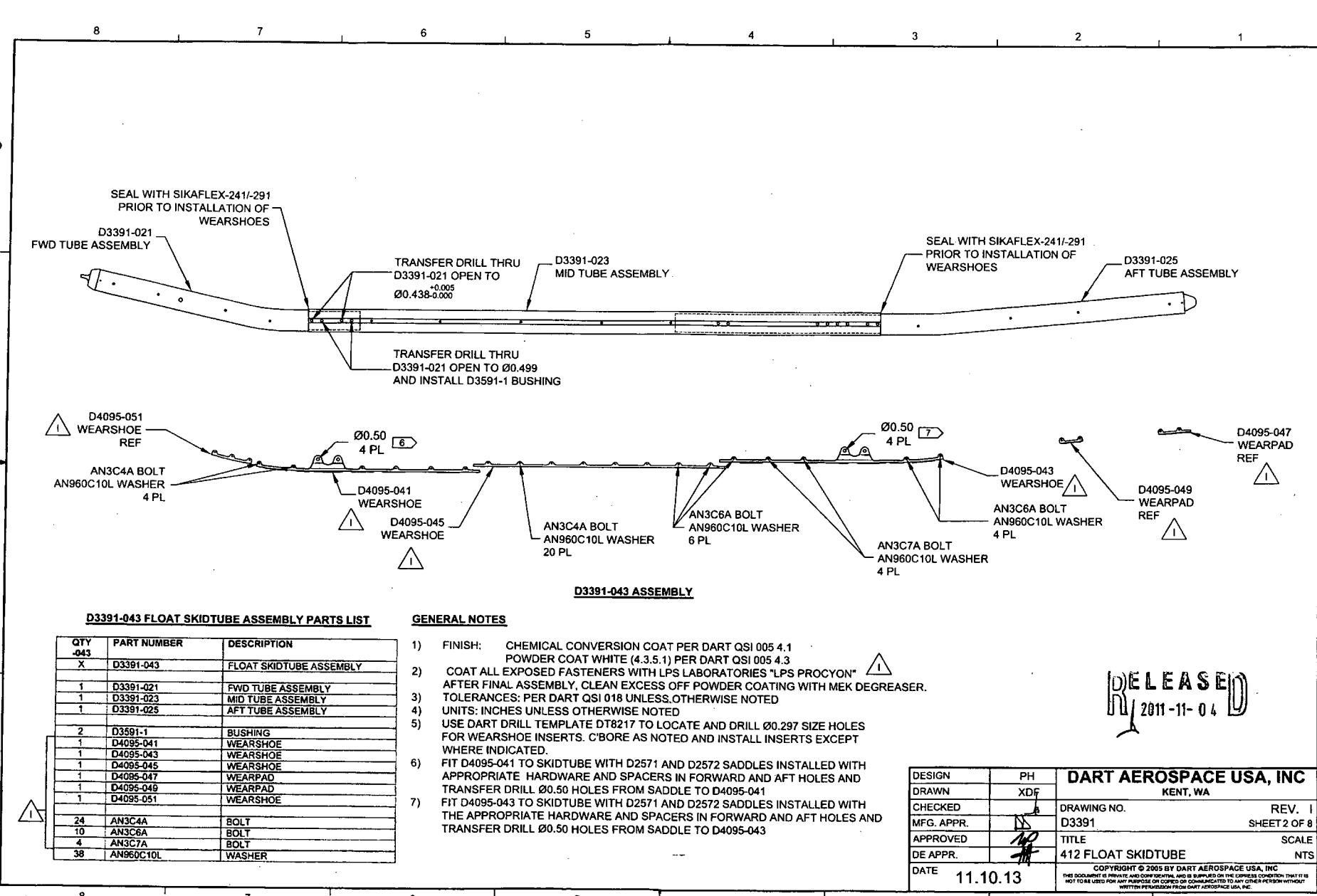
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

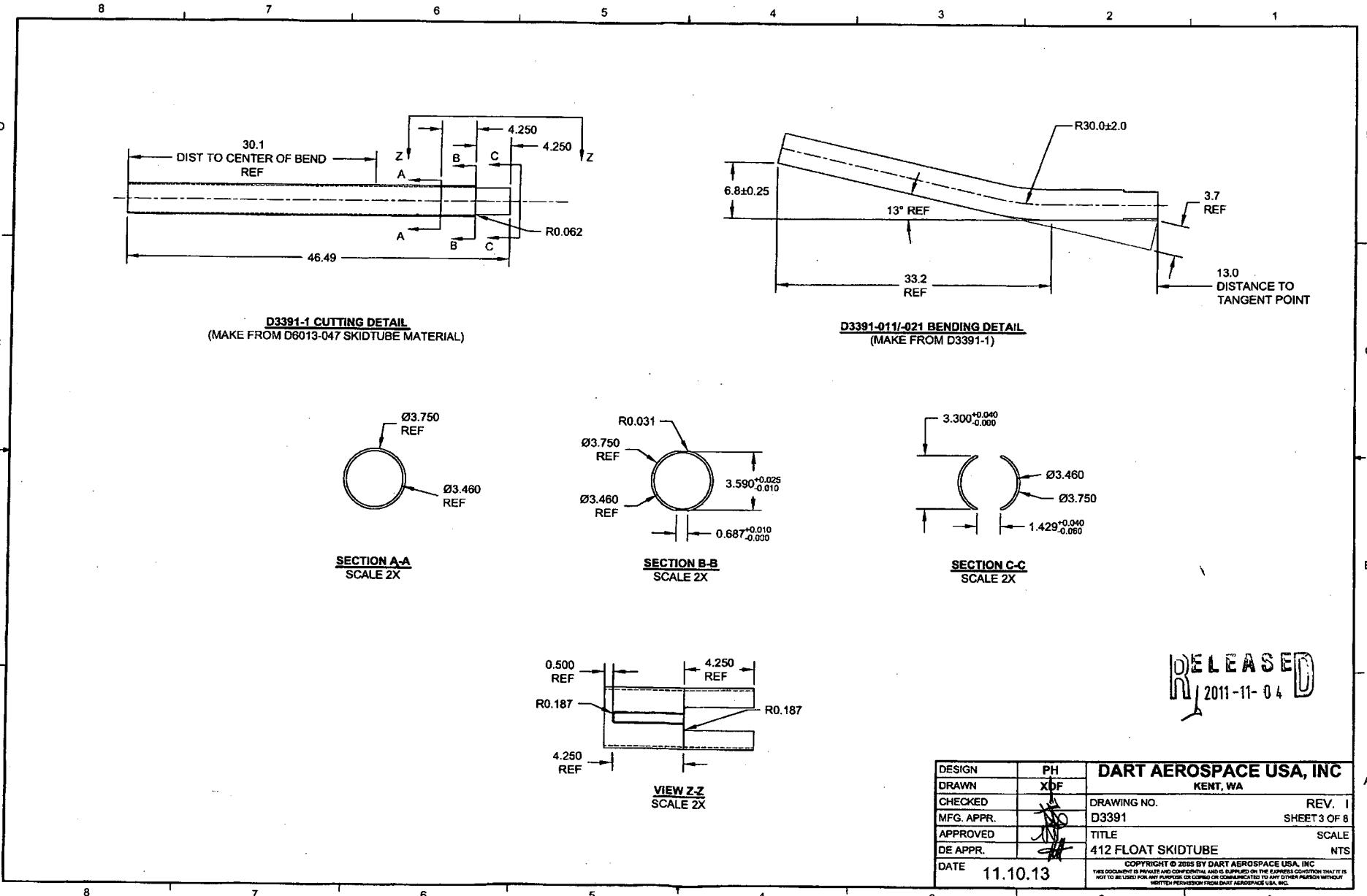
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

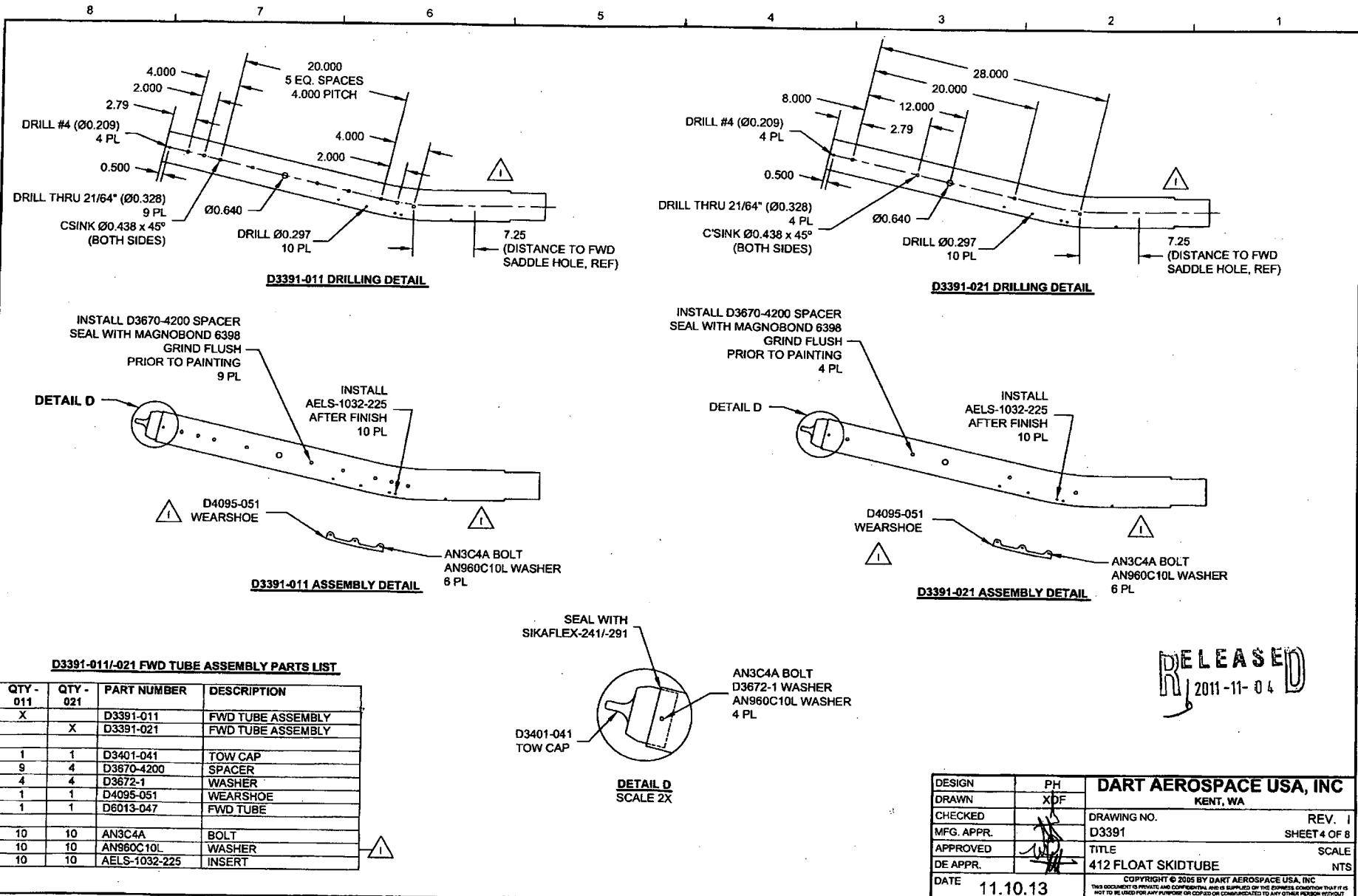
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DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 4 OF 8
APPROVED		TITLE	412 FLOAT SKIDTUBE
DE APPR.		SCALE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	

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